

Date: Thursday, 02/04/2009 2:25:41 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 46844	
Estimate Number : 11047	
P.O. Number :	Part Number : D28441
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D2844 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 39542	Material :
Written By :	Due Date : 10/04/2009
Checked & Approved By : <u>TWO 09.04.02</u>	Qty: 30 Um: 20 Each
Comment : Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.9941 f(s)/Unit Total: 39.8811 f(s)

304 RD Tube .500 x .035W

M304TRO500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using jig

DT 8012

Batch

M111097

(5X)

M 111409

(25X)



2.0	BRAKE NC	NC BRAKE
-----	----------	----------



(30X)

Comment: BAND SAW

Form per Dwg D2844 using brake and bending Jig DT 8238-B

Deburr

Mrb 09/05/28

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

Sork 5/29 counter (x30)

4.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

9:25

OVEN TEMPERATURE:

400°

FINISH TIME:

9:55

FL 09/06/01

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 46844

Part Number: D28441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-1 (30)

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

ensure parts are still as per dwg D2844

S 09/06/01 counter (x30)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 265

9/6/11

(3DX)

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/01 J

Job Completion



MF 09-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

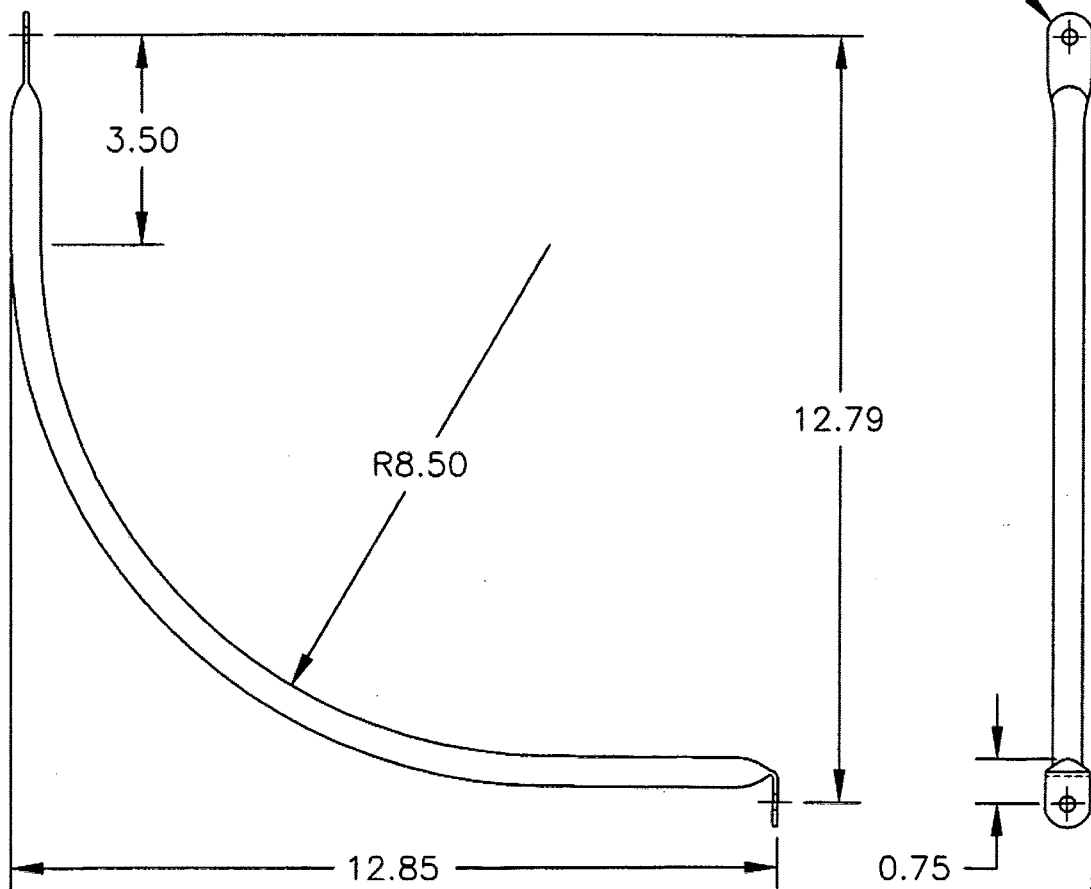
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

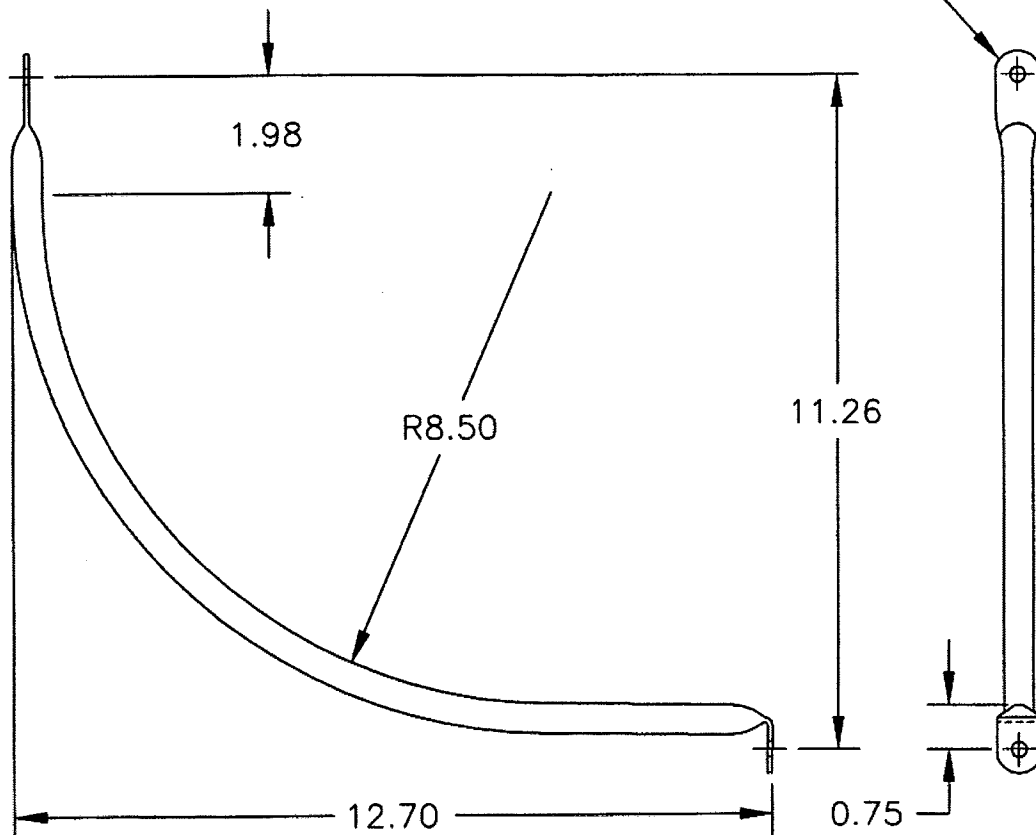
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CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
18.11.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

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